



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1816

Job Sheet 168296



Part No: 647.1816

Job Qty: 4 ea

Part Name: Support LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV N/C SHEET 6 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/27/17	0.00	0.00	Start Up Container		on 17/12/27
110	Waterjet	4 pcs		11/27/17	0.00	0.66	Waterjet1		on 17/12/27
120	QC	4 pcs		11/27/17	0.00	0.00	QC2		on 17/12/27
130	QC	4 pcs		11/27/17	0.00	0.00	QC8		38
140	Brake NC	4 pcs		11/27/17	0.00	2.02	Brake NC 1		DAS-88 38 PTO
150	QC	4 pcs		11/27/17	0.00	0.00	QC5		38
160	Outsource	4 pcs		11/27/17	0.00	0.00	Outsource4		9-88
170	Packaging	4 pcs		11/27/17	0.00	0.00	Packaging2		
180	QC	4 pcs		11/27/17	0.00	0.00	QC5		
190	SprayPaint	4 pcs		11/28/17	0.00	0.77	Spray Paint		
200	QC	4 pcs		11/28/17	0.00	0.00	QC14		
210	Packaging	4 pcs		11/28/17	0.00	0.00	Packaging3		
220	QC21-SA	4 Ea		11/28/17	0.00	0.00	QC21		

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A ***grain direction on a 45 degree*** 2-Deburr if Descriptions: necessary

160 - ISSUE P/O: 038842 HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH:

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

JAN 22 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	1	309	0	0

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:47 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No _____ NCR No _____ Date : _____ <i>Part out of 1 To perane</i>	DISPOSITION PART AEROSPACE S026950 Support LH	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width:25%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width:25%;"> Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐ </td> <td style="width:25%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width:25%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> <tr> <td colspan="3" style="padding: 5px;">QTY Effective : _____</td> <td style="padding: 5px;">MRB (QSI042) Approv _____</td> </tr> <tr> <th colspan="4" style="text-align: center; padding: 5px;">Disposition</th> </tr> <tr> <td colspan="3" style="height: 100px; vertical-align: middle; text-align: center;"> Scrap & destroy No replace </td> <td style="vertical-align: top; padding: 5px;"> Completed By  Lead hand / Supervisor Approval Verification DAS 30 9-89 </td> </tr> <tr> <td colspan="3" style="padding: 5px;">QC / QA Coordinator Approval _____</td> <td></td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	QTY Effective : _____			MRB (QSI042) Approv _____	Disposition				Scrap & destroy No replace			Completed By  Lead hand / Supervisor Approval Verification DAS 30 9-89	QC / QA Coordinator Approval _____			
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Mfg Date: 12/27/17 Job No: 168296 <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table> <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Past Due</td><td>☐</td></tr> </table>	Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	Manufacturing Process	☐	Past Due	☐	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left; padding: 5px;">FAULT CATEGORY</th> </tr> <tr> <td style="width:33%;"> Temperature/Cure ☐ -up ☐ VI/Route ☐ ken/Damage/Defect ☐ ection Incomplete/Unqualified ☐ tamination ☐ ntersink ☐ Too Short ☐ uctions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimension ☐ ☒ Over/Under tolera Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>	FAULT CATEGORY			Temperature/Cure ☐ -up ☐ VI/Route ☐ ken/Damage/Defect ☐ ection Incomplete/Unqualified ☐ tamination ☐ ntersink ☐ Too Short ☐ uctions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimension ☐ ☒ Over/Under tolera Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Equip/Tooling	☐																																		
Handling/Pre	☐																																		
Material	☐																																		
Internal Transport	☐																																		
Tribal Knowledge	☐																																		
LOA	☐																																		
Substation	☐																																		
Past Expiry Date	☐																																		
Misidentified	☐																																		
Manufacturing Process	☐																																		
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03686				SHEET 1 OF 2	
	DWG NO. 647.1800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	EFFECT ON DWG ☒ INC. ☐ UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED RADIUS ON SHEETMETAL BEND.			ECR: D-12-020	

NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 1 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

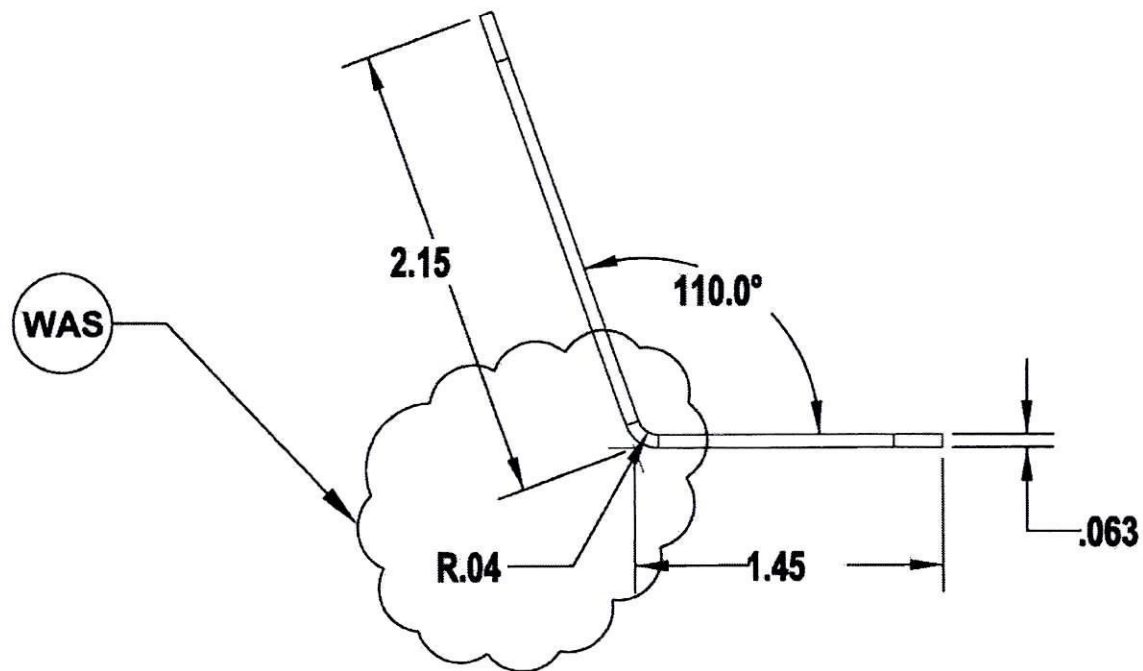
SHEET 1, ZONE A1 WAS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168 296

DAS
30
9-89

NOV 16 2017

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

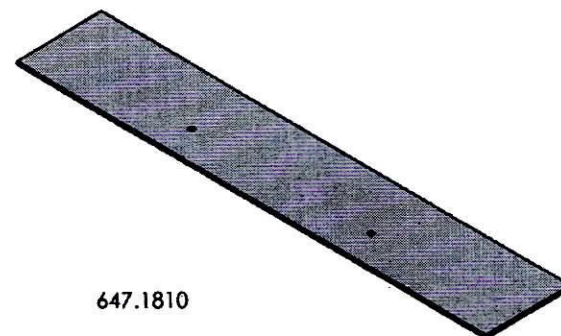
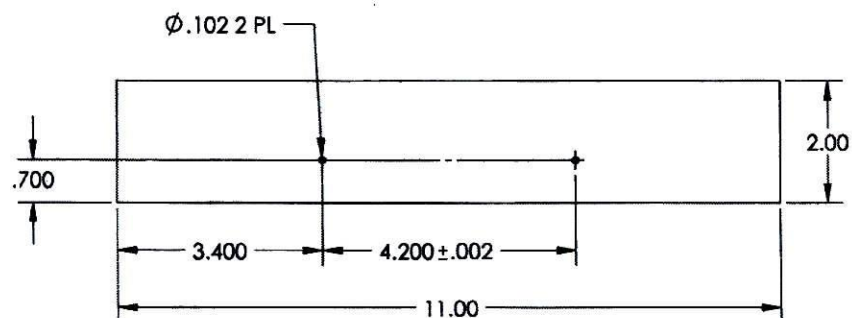


SHEET 4, ZONE D5 WAS:

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NOTES:

- ⚠️ PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11
- ⚠️ FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



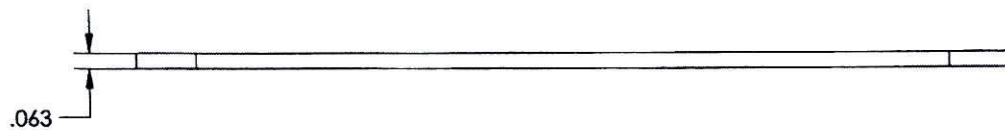
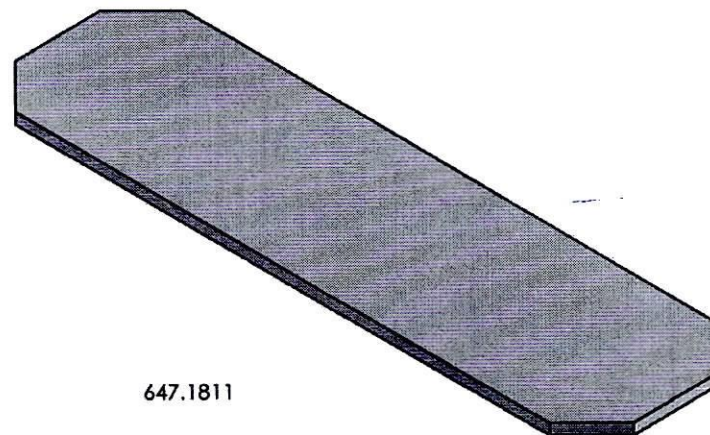
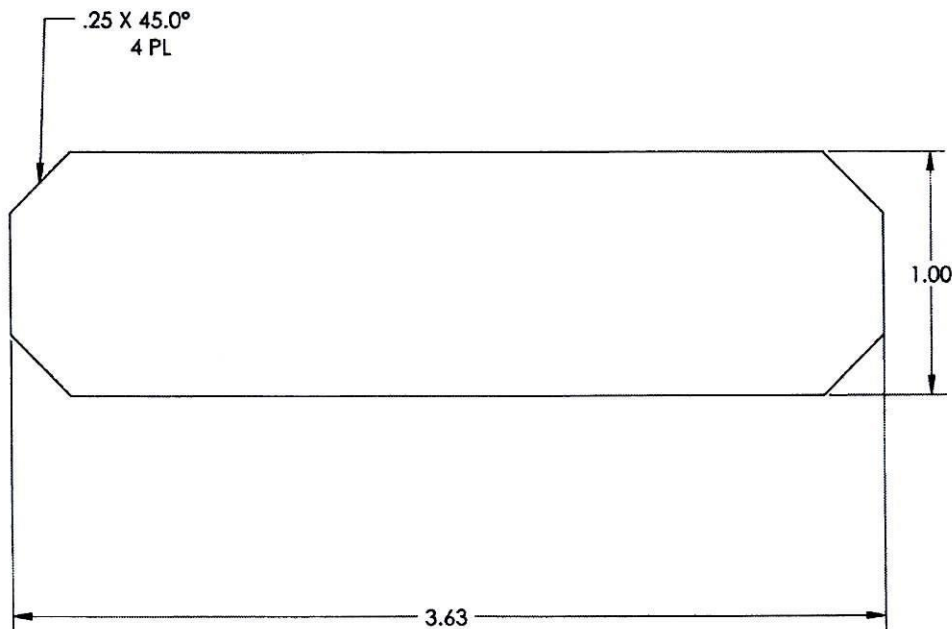
647.1810

- .063

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: P92		N/C
N/C	INITIAL RELEASE	06/01/09	P. BRAVO
A	INCORPORATED ECN 03884	11/12/12	P. BRAVO

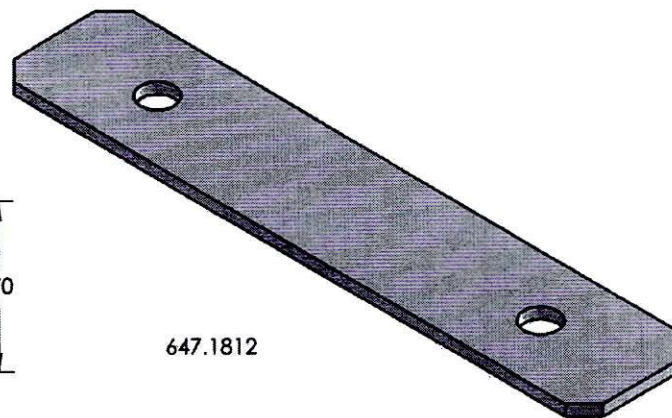
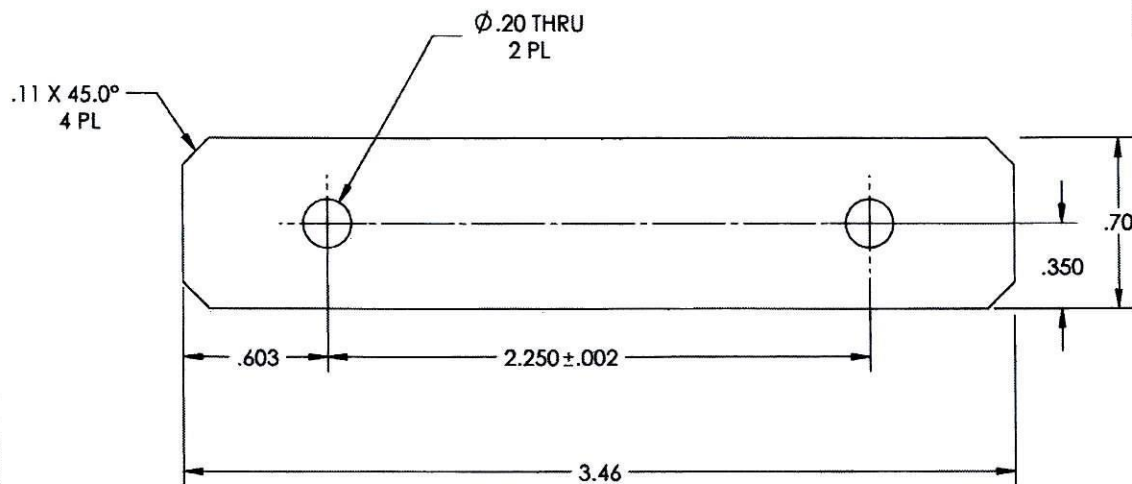
				647.1818	NOSE DOOR SPACER	△	△
				647.1817	SUPPORT, RH	△	△
				647.1816	SUPPORT, LH	△	△
				647.1815	GUSSET, RH	△	△
				647.1814	GUSSET, LH	△	△
				647.1813	ANGLE	△	△
				647.1812	SHIM	△	△
				647.1811	SPACER	△	△
				647.1810	NOSE DOOR DOUBLER	△	△
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY				PARTS LIST			
NEXT ASSY [S]				APICAL INDUSTRIES			
647.1300				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
ORIGINAL DATE 06-03-09 MOD-DATA-TYPE 01-01-09 DRAWN BY C. SCHNEIDER I.G. ARNONE P. BRAVO DATE/REV APPROVAL 06-03-09 REVISIONS CHECKED BY				SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°				REV. A			
				SIZE GAUGE CODE B 07/MZE		DWG NO. 647.1800	
				SCALE NONE		1 SHEET 1 OF 7	

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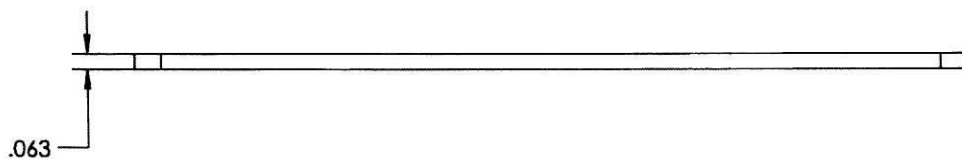


ORIGINAL DATE 10/02/07		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		REV. A	
DESIGNED BY J. GARDNER		DWG. NO. 647.1800	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ± .5°		SHEET 2 OF 7	

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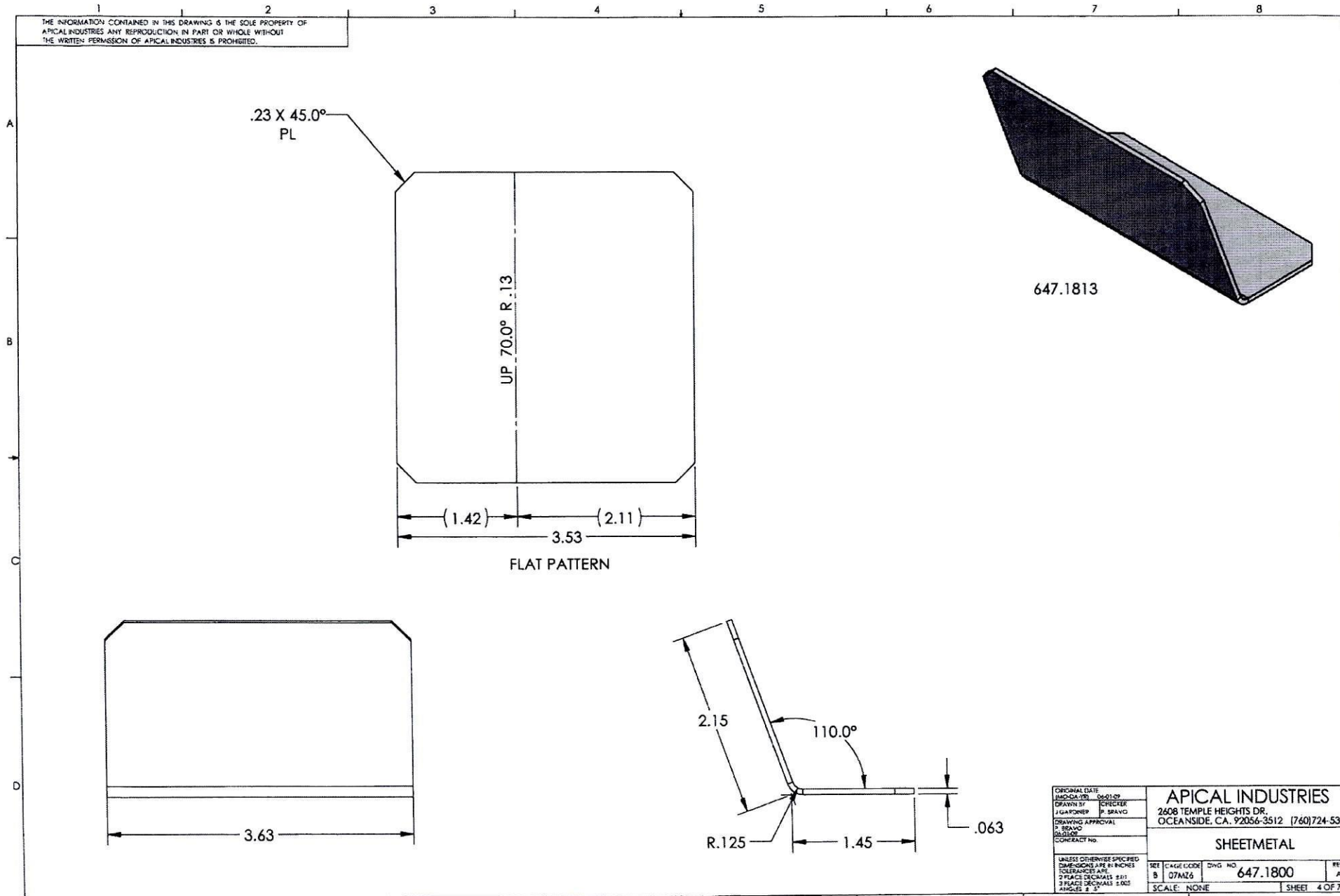


647.1812



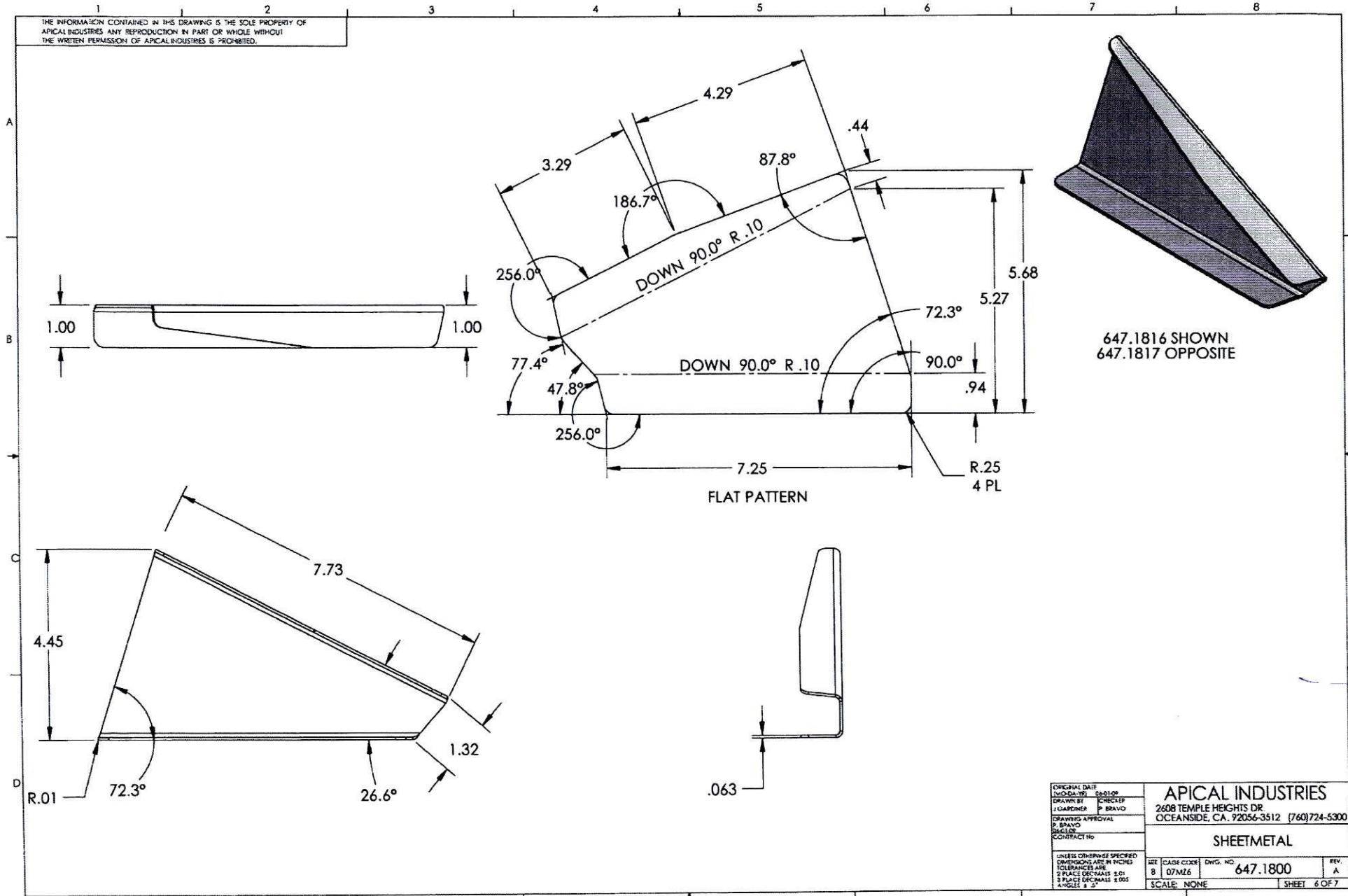
ORIGINAL DATE 10/20/07		CHECKED J. GARDNER		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		P. BRAYO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAYO		10/20/07		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.				SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .000$ ANGLES $\pm .5^\circ$		SIZE B	CAGE CODE 07M26	DWG. NO. 647.1800	REV A
		SCALE: NONE		SHEET 3 OF 7	

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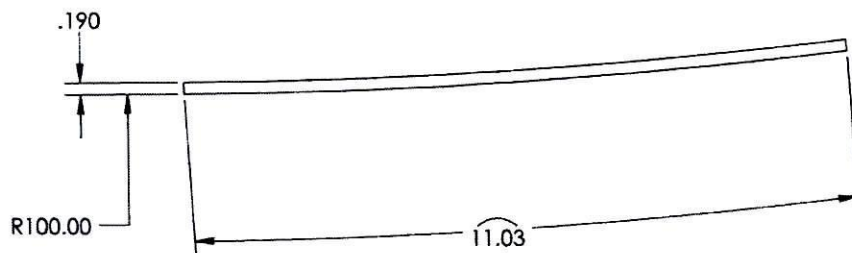
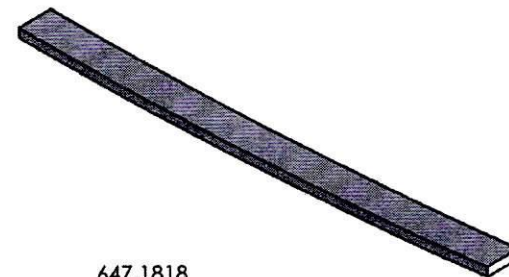
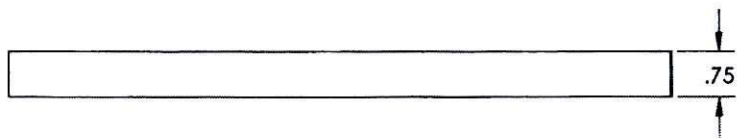
ORIGINAL DATE 1/20/2010		APICAL INDUSTRIES	
DRAWN BY J. GAYNER	CHECKED BY P. BRAY	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAY		SHEETMETAL	
CONTRACT NO.		REV. A	647.1800
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SCALE: NONE	SHEET 4 OF 7

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ORIGINAL DATE 1/10/04-1/11/04		DESIGNER J. GARDNER		CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO		SCALE AS SHOWN		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°					
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300					
SHEETMETAL					
SHEET 8	CASH CODE 07/M26	DWG. NO. 647.1800	REV. A		
SCALE: NONE			SHEET 6 OF 7		

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ORIGINAL DATE 10/20/11	SHEET NO. 1
DRAWN BY J. GARDNER	CHECKED P. BRAVO
DRAWING APPROVAL P. BRAVO	
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°	
SEE B	CAGE CODE 07M26
DWG. NO. 647.1800	
SCALE: NONE	
SHEET 2 OF 7	

APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
SHEETMETAL	

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2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SHEETMETAL